

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028968**Date Inspected:** 09-Jan-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Fritz Belford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

This QA was tasked with checking the tracking records of the welding in the OBGs. Weld Visual, Magnetic Particle and Ultrasonic Test reports were compared to the tracking record to ensure all welds that were marked complete had documentation of the inspection and types inspections performed. Discrepancies were noted between the records and reports submitted and were corrected by re-inspecting the weld or by contacting the QA inspector involved to submit the appropriate report. This is an on going process to be completed as time and schedule allows.

This QA was present in the west tower to witness the Ultrasonic Testing of ESW welds by QC Inspector Andrew Keech. QC Inspector Keech was observed calibrating the scope utilizing the IIW block to verify transducer angle, linearity and sensitivity before starting his inspection of the weld. He was also noted calibrating the scope after the midday break before continuing with the Ultrasonic Testing of weld "N".

**Non-Destructive Testing (NDT)**

This QA performed Ultrasonic Testing on the following:

ESW N-041 "N":

o QA Verification Y 6750 to 9780 (Reject)

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## WELDING INSPECTION REPORT

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This QA Inspector completed report form TL-6027 on this date noting items acceptance or rejection as per applicable code. The completed and accepted work observed at this location appeared to be in compliance with the contract specifications.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Conversations this day as required for scope of work.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas - (916) 764 - 6027, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Belford,Fritz	Quality Assurance Inspector
<b>Reviewed By:</b>	Reyes,Danny	QA Reviewer

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